

Date: Friday, 2/24/2006 1:22:42 PM
 User: Linda Lacelle

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAR
Job Number : 25939 A	
Estimate Number : 10390	
P.O. Number : N/A	Part Number : D3197041
This Issue : 2/24/2006 S.O. No. : N/A	Drawing Number : D3197 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 25459	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 3/3/2006
Checked & Approved By : USER ABOVE DATA & USER	Qty: 8 Um: Each
Comment : Est Rev: A New Issue 05-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M7075T73R1000	7075-T73 Round Bar 1" OD
Comment: Qty.: 2.5410 f(s)/Unit Total : 76.2300 f(s) Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) Identify for D3197-1 Batch: _____ <i>M100068 (19.42 feet x 8 pcs) In 06/02/24</i>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 29.125" long <i>SA 06.02.27 (8)</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 3-Deburr <i>SA 06.02.27 (8)</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SA 06.02.27 (8)</i>		
5.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE Chamfer as per Dwg D3197 <i>SA 06.02.27 (8)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25939

Part Number: D3197041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

136 06-02-27

8

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MA 06-02-28

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Q. m 06-02-28

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06-03-01

8

10.0	D26905	Lanyard ass'y
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2690-5 Lanyard B25104 (3)
B25475 (13)

11.0	D32421	Tag
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3242-1 TAG B25400

12.0	AN960JD10	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 360.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD10 Washer M19413

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 04/03/02

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/24/2006 1:22:43 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25939

Part Number: D3197041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 DARS004 Pip Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ~~DARS-004~~ Pip Pin

JE 806-206

Batch # 100069

W
see DST cl.

14.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21042L3 Nut (or -3) M18615

15.0 MS27039124 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-24 Screw M19391

SAD 06:03:01

8

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3197-041 as per Dwg D3197

SAD

06:03:01

8

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06:03:01 8

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST137

C 206103101

8

19.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06:03:02 8

W 06:03:02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

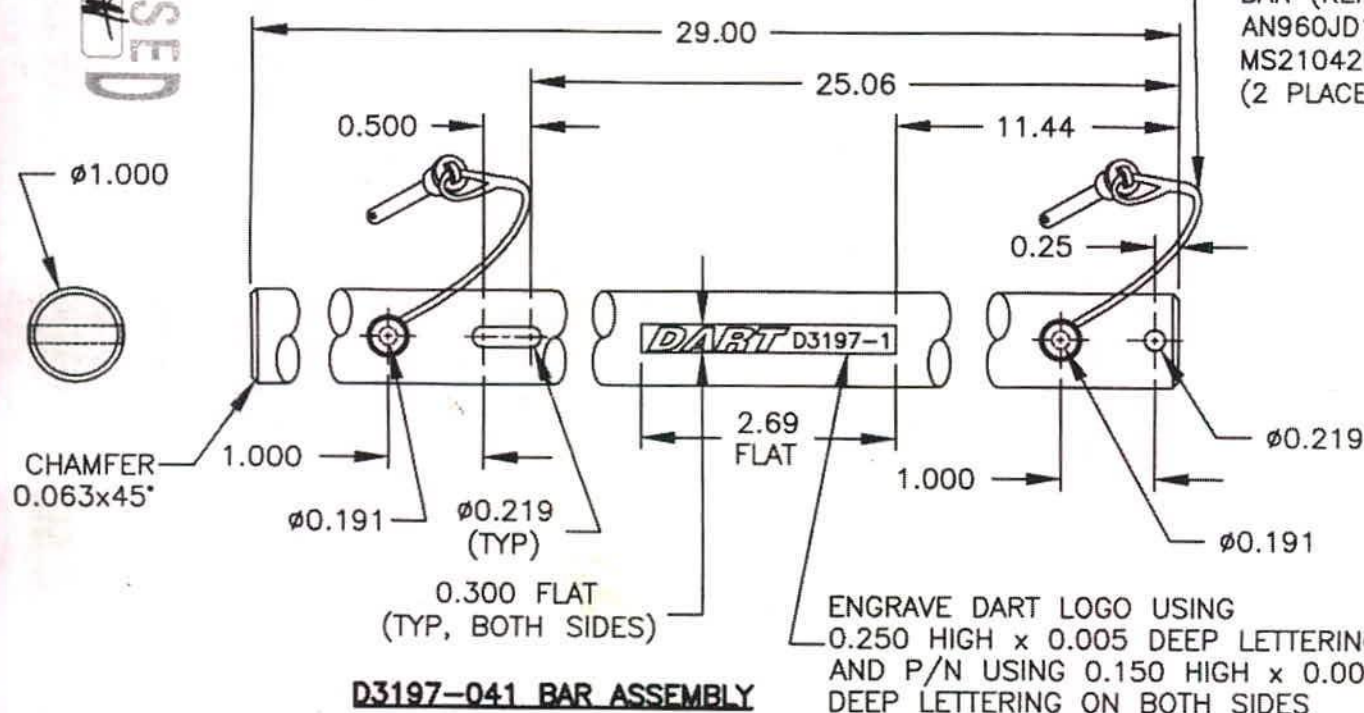
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	CHECKED	APPROVED	DRAWING NO.	REV. A
A1	04.01.12	03.07.01	03.07.01	D3197	SHEET 1 OF 1
DATE	03.07.01	03.07.01	03.07.01	BAR	SCALE
03.07.01	03.07.01	03.07.01	03.07.01	ADD D3242-1 TAG	1:1

D3242-1 TAG (1)
 DARS-004 PIP PIN (1)
 MS27039-1-24 BOLT (1)
 AN960JD10 WASHER (1)
 D2690-5 LANYARD (1)
 AN960JD10 WASHER (1)
 BAR (REF)
 AN960JD10 WASHER (1)
 MS21042L3 NUT (1)
 (2 PLACES)



D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY.
IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN WITH A ϕ 0.188 DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

RELEASED
03.10.10

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